

5841

Date: Tuesday, 15/08/2006 2:19:21 PM  
User: Linda Lucelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FOLDING STEP WELDMENT LH
Job Number : 28198	
Estimate Number : 10463	
P.O. Number : <i>N/A</i>	Part Number : D3388041
This Issue : 15/08/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3388 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 27272	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 22/08/2006 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. B 05.06.10 Added Step 11 KJ/JLM Est Rev:C Revised Steps 06-06-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
D2622-120C extrusion 8  
Batch: *327072*

*P.E. 06.08.15 4*

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1  
1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388  
2-Deburr and bevel ends for welding

*P.E. 06.08.15 4*  
*P.E. 06.08.15 4*

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
206 Step Endplate  
Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>327231</i>

*P.E. 06.08.15 4*

4.0	D33871	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Arm  
Pick:

Qty	Part Number	Description	Batch
2	D3387-1	Arm	<i>327104</i>

*P.E. 06.08.15 4*





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Job Number: 28198

Part Number: D3388041

Job Number:



Seq. #:

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Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and fwd end cap as per Dwg D3388.

A/R AL ROD Batch: M180660Dwg Rev: A

2-Grind end cap welds flush

L.E. 06.08.16

4

L.E. 06.08.16

4

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06.08.16 (4)

M06/08/16 (4)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06.08.16

(4)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign objects as per QSI 024.

2-Weld last end cap as per Dwg D3388.

A/R AL ROD Batch: M100660Dwg Rev: A M15689

2-Grind end cap welds flush

L.E. 06.08.22

4

L.E. 06.08.22

4

L.E. 06.08.22

4

L.E. 06.08.22

4

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06.08.23 (4)

M06/08/29 (4)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical conversion.

L.M. 06-08-30

(4)





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Part Number: D3388041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

G-m

06-08-29

(4)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

a.m

06-08-30

(4)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

D2808

B

28600

06/12/13

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



06/12/14  
06.12.14

